

Work Order ID 83822

Thursday, April 26, 2012 1:07:29 PM

83822

ASAP

Page 1

Item ID: D4062-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Upper Tank Support
 Start Date: 4/26/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 5/3/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: UMF Date: 12-04-26 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4062	C					(2)			

100 0.00
100
 Waterjet Memo 0.00
 FLOW CNC Waterjet CUT BLANK AS PER FILE D4062-1_BLANK
 UMF 1" 12-4-09

102 QC2- Inspect parts off machine FAI/FAIB 0.00
102
 QC Memo 0.00
 Quality Control 12-4-09

105 0.00
105
 HAAS I Memo 0.00
 HAAS CNC vertical machine #1 MILL AS PER DWG AND FOLIO FA949
 DWG REV: C
 FOLIO REV: AA
 12-05-05
 12-5-5

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 Start Date: 4/26/2012 Start Qty: 1.00 ***1*** Cust Item ID:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
106 *106* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00	2L 12-05-03 A 12-5-5			2 2	0 0		
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	2L 12/05/03			2 0	0 0		
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: <u>WMA</u> Memo	0.00 0.00				2 0	0 0		12.05.04

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 4/26/2012 **Start Qty:** 1.00

*** 1 ***

Cust Item ID:

Required Date: 5/3/2012 Req'd Qty: 1.00

*** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

812-05-4

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 83822

Parent Item: D4062-1

Parent Item Name: Upper Tank Support

Start Date: 4/26/2012

Required Date: 5/3/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 10-06-22 JLM VERIFIED BY:DD IPP REV:B AS PER REV B 11-11-23 JLM VERIFIED BY:DD IPP REV:C AS PER REV C 12-03-08 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No				sf	238.4100		3.6			
UHMW 1" Black													

B12-4-27

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT018	30.1	
120972	3	
121346	27.1	
MAT019	1.5	
118814	1.5	
ST052	206.8099947	
121277	20	
121278	186.809995	

121277

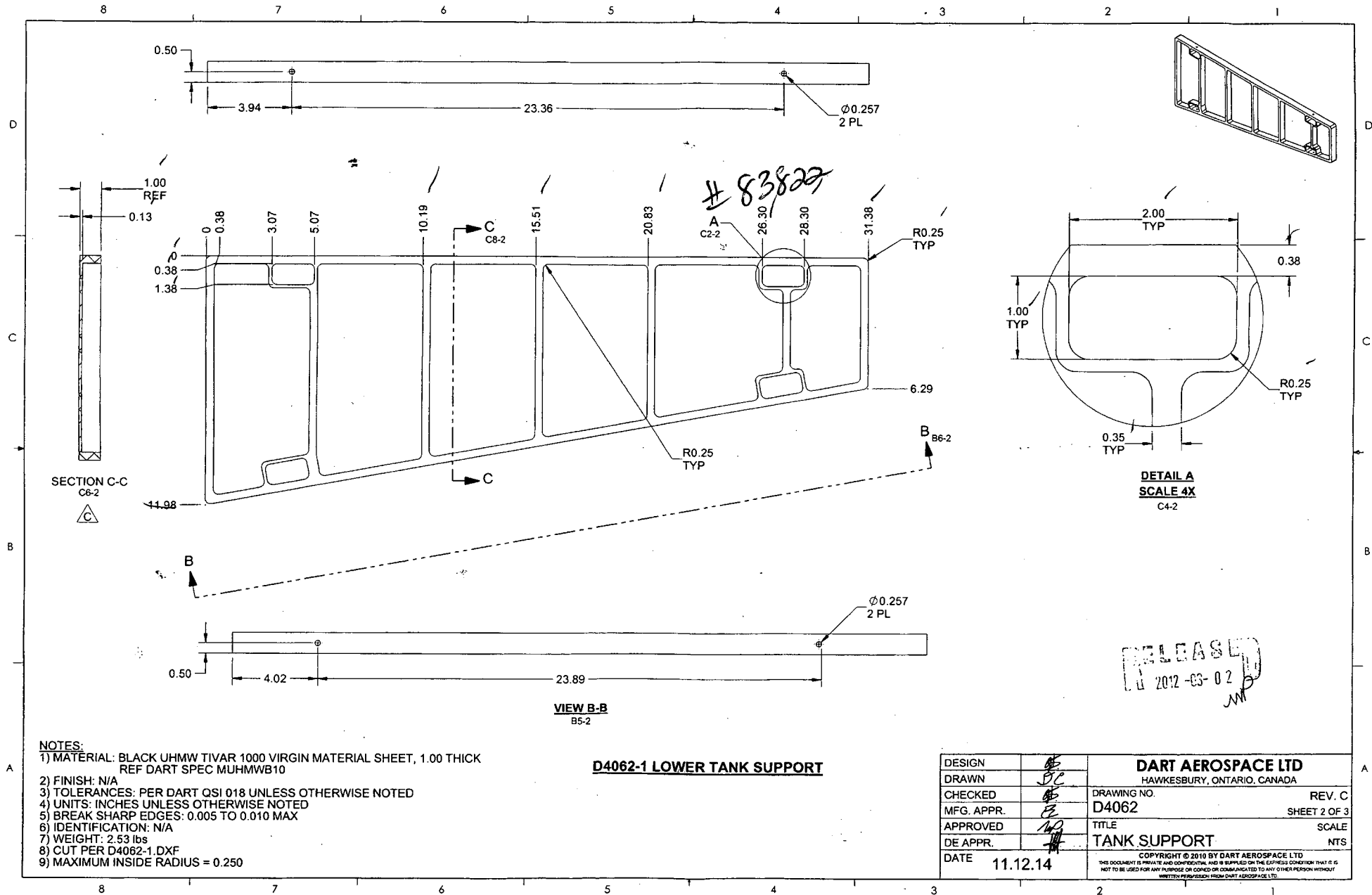
W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE				By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries



DESIGN	<i>JS</i>	DART AEROSPACE LTD	
DRAWN	<i>JS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JS</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>JS</i>	D4062	SHEET 2 OF 3
APPROVED	<i>JS</i>	TITLE	SCALE
DE APPR.	<i>JS</i>	TANK SUPPORT	NTS
DATE	11.12.14	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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DART AEROSPACE LTD		Work Order: 83822
Description: lower tank support		Part Number: D40621
Inspection Dwg: D4062	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	$\pm .030$	1.000	✓		Vern SL-10	
.13	$\pm .030$.145	✓		AG	
2.00	$\pm .030$	2.001	✓		Vern SL-10	
1.00	$\pm .030$	1.001	✓		-	
.35	$\pm .030$.352	✓		-	
6.25	$\pm .030$	6.250	✓			
.38	$\pm .030$.375	✓		-	
.38	$\pm .030$.374	✓			
1.38	$\pm .030$	1.375	✓			
#.98 .25	$\pm .030$.25	✓			
31.38	$\pm .030$	31.375	✓		mtape	
28.3	$\pm .03$	28.3	✓		~	
26.3	$\pm .030$	26.3	✓		~	
20.83	$\pm .030$	20.83	✓		-	
15.51	$\pm .030$	15.51	✓		~	
10.19	$\pm .030$	10.19	✓		Vern CMC-02	
5.07	$\pm .030$	5.07	✓		-	
3.07	$\pm .030$	3.07	✓		-	
23.89	$\pm .030$	23.88	—		RA21	
23.36	$\pm .030$	23.37	—		RA21	Tape
.50	$\pm .030$.487	—		RA26	Vern
Ø.257	$\pm .005$ $-.001$	Ø.257	—		RA26	Vern

Measured by: SL <i>[Signature]</i>	Audited by: <i>[Signature]</i>	Preliminary Approval:
Date: 12-05-05	Date: 12/05/03	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

[Signature] 10.04.15

